

SOLD 5048097



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-5

Job Sheet 172534



Part No: D4776-5

Job Qty: 24 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 3/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS PER
REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	24 Ea		3/1/18	0.00	0.00	Start Up Machining-3		M.D. 18/03/06
100	Doosan	24 pcs		3/1/18	0.05	1.34	Doosan		M.D. 18/03/06
120	QC	24 pcs		3/1/18	0.00	0.00	QC8		S.C.L. 18-03-06
130	HandFinish	24 pcs		3/2/18	0.00	0.12	HandFinish1		SA 18-3-6
140	QC	24 pcs		3/2/18	0.00	0.00	QC7-4		
150	Packaging	24 pcs		3/2/18	0.00	0.00	Packaging3-2	5/115	38 MAR 06 2018
160	QC21-SA	24 Ea		3/2/18	0.00	0.00	QC21		21 MAR 07 2018

Part Op 100 - 1-Turn as per Folio and Dwg
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.500	6061-T6 Round Bar .500"	.4800 ft (.02 ea)	90-Start up Operation	

Job Allocations

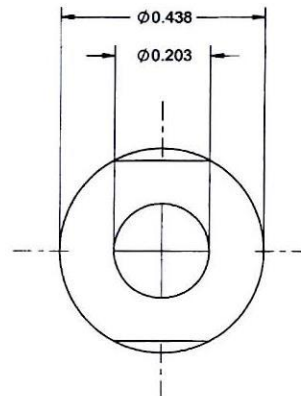
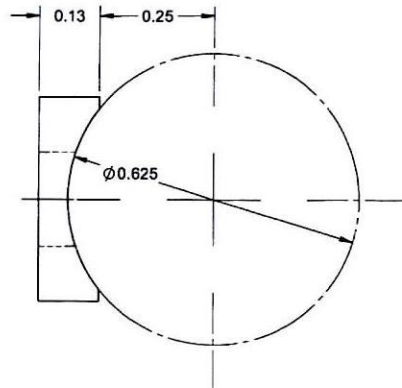
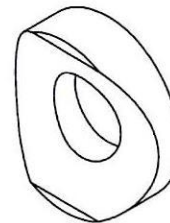
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.500	0	57	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches ± 0.030	0.160 0.100		
2	Spacer	0.250Inches ± 0.030	0.280 0.220		
3	Spacer	0.625Inches ± 0.010	0.635 0.615	Diameter	
4	Spacer	0.438Inches ± 0.010	0.448 0.428	Diameter	
5	Spacer	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

Plex 2/20/18 11:23 AM dart.logan.david

8 7 6 5 4 3 2 1



D4776-5 SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 172534
WORK ORDER

20180220

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4776-5" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: LESS THAN 0.01 lbs

RELEASED
2014-07-30

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	AJS	D4776	SHEET 3 OF 3
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	BASKET STRUT MACHINED PARTS	NTS
DATE	14.07.14	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

DOA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

FAULT CATEGORY

ire	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
/Defect	☐ Weld	☐ Part Incorrect
nplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
omplete/Unclear	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

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Date: 03/06/18

Container No: S048098

Part: D4776-5

Job No: 172534

Serial No/Batch: S048098

Revision:
Inspector: